

# Work Order ID 88946

**\*88946\***

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Saturday, August 11, 2012 12:38:20 PM

Item ID: D3642-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Doubler  
 Start Date: 8/13/2012 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 8/24/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/08/13 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3642	Rev B								

100 FLOW WATER JET 0.00  
**\*100\***  
 Waterjet Memo 0.00 8 0 Jim 12-8-18  
 FLOW CNC Waterjet 1-Cut as per Dwg D3642 Dwg Rev: B Prog Rev: B 2-  
7674 .050 Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00  
**\*110\***  
 QC Memo 0.00 8 0 Jim 12-8-18  
 Quality Control

120 QC8- Inspect parts - second check 0.00  
**\*120\***  
 QC Memo 0.00 76  
 Quality Control

DAS  
16  
8-18  
7/06/70

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Saturday, August 11, 2012 12:38:20 PM

Item ID: D3642-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Doubler

Start Date: 8/13/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 8/24/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Chemical Conversion Coat per QSI005 4.1

0.00

**\*130\***

HandFinish

Memo

0.00

Hand Finishing

8 76 12-8-22

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/8/2254

150

Identify as per dwg &amp; Stock Location 244

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

8 2 12/08/22

**Work Order ID 88946****\*88946\***

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Saturday, August 11, 2012 12:38:20 PM

Item ID: D3642-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Doubler

Stop **\*NS2\***

Start Date: 8/13/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 8/24/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

MCS 12 1081 23

ME  
12-08-23

# Picklist Print

Saturday, August 11, 2012 12:38:19 PM

Page 1

Work Order ID: 88946

Parent Item: D3642-1

Parent Item Name: Doubler

Start Date: 8/13/2012

Required Date: 8/24/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

2024-T3 .050 sheet

Purchased

No

100

sf

235.7484

0.1664

~~1.4012632~~

1.5

Jm 12-8-13

Location

Loc Qty

Loc Code

MAT022

235.7484204

117684

22.8

121216

87.4484204

121889

125.5

121889

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
<b>FAULT CATEGORY</b>											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other		

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	88946
<b>Description:</b> Doubler		<b>Part Number:</b>	D3642-1
<b>Inspection Dwg:</b> D3642 <b>Rev:</b> B		<b>Page 1 of 1</b>	

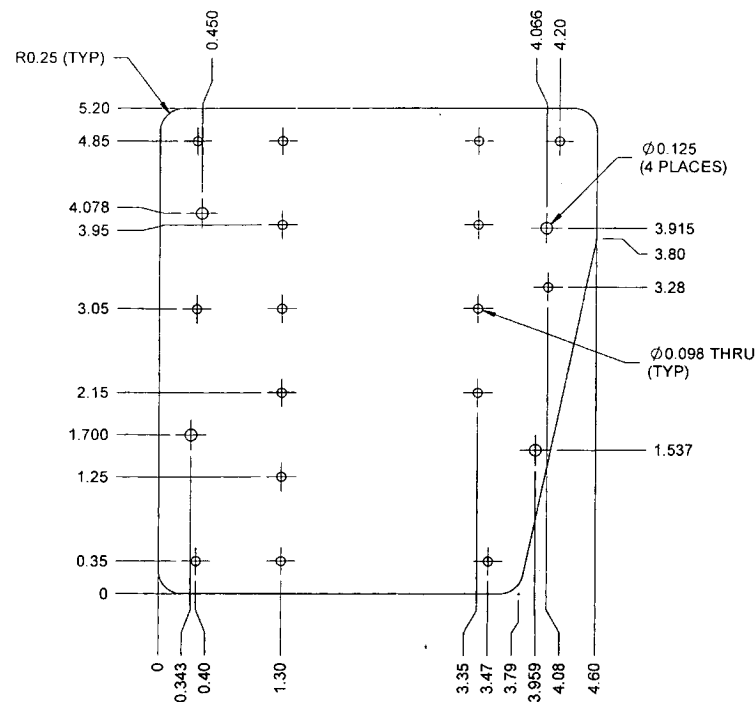
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.125	+0.004/-0.001	0.127"	✓		✓	mm01
Ø0.098	+0.004/-0.001	0.099"	✓		✓	
0.35	+/-0.030	0.354"	✓		✓	
1.25	+/-0.030	1.255"	✓		✓	
1.700	+/-0.010	1.703"	✓		✓	
2.15	+/-0.030	2.155"	✓		✓	
3.05	+/-0.030	3.052"	✓		✓	
3.95	+/-0.030	3.953"	✓		✓	
4.078	+/-0.010	4.079"	✓		✓	
4.85	+/-0.030	4.851"	✓		✓	
5.20	+/-0.030	5.202"	✓		✓	
0.343	+/-0.010	0.346"	✓		✓	
0.40	+/-0.030	0.399"	✓		✓	
1.30	+/-0.030	1.301"	✓		✓	
3.35	+/-0.030	3.354"	✓		✓	
3.47	+/-0.030	3.471"	✓		✓	
3.79	+/-0.030	3.790"	✓		✓	
3.959	+/-0.010	3.961"	✓		✓	
4.08	+/-0.030	4.089"	✓		✓	
4.60	+/-0.030	4.602"	✓		✓	
1.537	+/-0.010	1.535"	✓		✓	
3.28	+/-0.030	3.275"	✓		✓	
3.80	+/-0.030	3.80"	✓		✓	
3.915	+/-0.010	3.916"	✓		✓	
0.450	+/-0.010	0.455"	✓		✓	
4.066	+/-0.010	4.068"	✓		✓	
4.20	+/-0.030	4.202"	✓		✓	

<b>Measured by:</b>	JM	<b>Audited by:</b>	DAS	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	12-8-18	<b>Date:</b>	16 17/08/20	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	
B	08.12.01	Dimensions updated per Dwg Rev. B	KJ/EC	



**D3642-1 DOUBLER (WAS GENEVA P/N G10607-1/-2)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 88946 MLC

12/08/13

RELEASED  
07.10.16

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3642-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

B	REMOVE -2; UPDATE -1 TO INCLUDE G10607-2	LE	07.10.16
A	NEW ISSUE; REPLACES G10607	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LG		
CHECKED	RA		
MFG. APPR.	EG		
APPROVED	JS		
DE APPR.			
DATE	07.10.16		

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

DRAWING NO. **D3642** REV. B  
SHEET 1 OF 1  
TITLE **DOUBLER** SCALE 4:5

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